

WORK ORDER 2010-04

Date opened: 17 February 2010

Project: Quick Release Cargo Basket Assembly
Type: Eurocopter AS350/355 SeriesBatch Quantity: 3 Complete Basket Assembly (76410-01)
Right Hand Configuration
2 Modified with Open Front End (70406)
3 Modified with Lid Step (70405)Approval: SH08-16
Drawing List: DCL764-3

Fabrication and Assembly Drawing(s)	Description
76410, Rev. 2	Basket Ass'y
76411, Rev. 2	Basket Body Ass'y
69812, Rev. 2	Basket Lid Ass'y
84255, Rev. 0	Handle Installation
84261, Rev. 0	Handle Bar Ass'y
84262, Rev. 0	Handle Bracket Ass'y
70405, Rev. 2	Lid Step Modification
70406, Rev. 1	Front End Cutout Modification

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	Y
Document Control List revision level matches (or exceeds) STC:	Y
Drawings revision levels match Document Control List:	Y
Purchase order or Work order source is recorded for each part/ass'y:	Y
Tests and inspections specifically called out on drawings are complete:	Y
Release tags associated with all fabricated parts are attached:	Y
All mounting hardware and supplies are included:	Y

List all non-conformities raised: _____

Welder Signature: _____ Date: _____

Inspector Signature: _____ Date: _____

Drawing: 76410 Revision 2
 Assembly: 76410-01 Cargo Basket Ass'y (Quick-Release, Medium, 75.75" long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	76410-01	Cargo Basket Assembly			
1	76411-01	Basket Body Assembly	Below		
1	69812-01	Basket Lid Assembly	Below		
1	84255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	8093	
1	MS20001P4	Piano Hinge		8104	
1	76427-01	Placard	0.063 Sheet, 6061-T6 Aluminum	10051	
3	49205-14	Bumper	Argus Industries Bumper	10026	
A/R	CR3213-5-02	Cherry Rivet		10089	
A/R	CR3523-5-02	Cherry Rivet		10064	
4	40088-14	Fitting	Ancra	10006	
4	AN960-616	Washer		10017/10025	
1	AN3-15A	Bolt		7077	
1	AN3-17A	Bolt		7077	
4	AN960-10	Washer		7077	
2	AN970-3	Washer		10049	
2	MS21044N3	Nut		8067	
				10025	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	Cherry Rivets		
Final Inspection	Drawing 76410			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 76411 Revision 2
 Assembly: 76411-01 Basket Body Ass'y (Quick-Release, Medium, 75.75" long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	76411-01	Basket Body Assembly			
A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	8087	
A/R		Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	9057	
3	76421-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube		
1	76422-01	Attachment Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube		
1	76423-01	Attachment Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube		
1	84262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	7007	
A/R	3/4-16F	Mesh	Expanded carbon steel	8094	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 76411			
Final Inspection	Drawing 76411			

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Drawing: 69812 Revision 2
 Assembly: 69812-01 Basket Lid Ass'y (Quick-Release, Medium, 75.75" long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	69812-01	Basket Lid Assembly			
2	69824-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8087	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	↓	
3	49213-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	7007	
1	49216-01	Spacer	1018 Steel, 1/2" Rod		
1	84262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9010	
A/R	3/4-16F	Mesh	Expanded carbon steel	8094	

Note: 2 lids are from WO2008-10, converted to new handle system


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 69812			JC.
Final Inspection	Drawing 69812			JC.

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Drawing: 84255 Revision 0
 Assembly: 84255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	84255-01	Handle Installation			
1	84261-01	Handle Bar Assembly	Below		
2	84267-01	Bracket	3/4" Delrin Sheet	WO 2009-29	
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	2091	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	6068	
4	AN3-11A	Bolt		10082	
2	AN3-12A	Bolt		10049	
12	AN960-10	Washer		10082	
6	MS21044N3	Nut		10049	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			

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Drawing: 84261 Revision 0
Assembly: 84261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	84261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	10083	
2	84265-01	Lever	304 Stainless, 0.105 Sheet	10036	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	8076	
2	MS20615-4M3	Rivet		7039	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			je.

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Drawing: 36262 Revision 1
Assembly: 36262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	36261-01	Handle Bracket Assembly			
4	84272-01	Bushing	4130 Steel, 5/16 x 0.058 Tube	6076	
4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
2	36275-02	Support	304 Stainless, 5/16" Rod	8065	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			jc.

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Drawing: 70406 Revision 1
Assembly: 70406-01 Open Front End Modification

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	70406-01	Open Front End Modification			
1	70406-03	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	9057	
1	70406-04	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	9057	
1	3/4-16F	Mesh	Expanded Carbon Steel	9057 8094	

Note: Remainder of assembly listed on drawing 76410

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70406			jc.

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Drawing: 70405 Revision 2
Assembly: 70405-01 Lid Step Modification

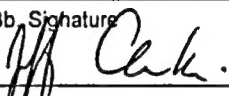
Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	70405-01	Lid Step Modification			
A/R	70405-03	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	9057	
1	70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	9054	
A/R	CR3213-4-2	Cherry Rivet		9078	

Note: Remainder of assembly listed on drawing 69812.

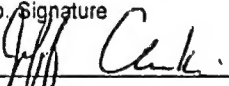
Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70405			gc.

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1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice 2010-04
6. Item	7. Description Cargo Basket	8. Part Number 76410-01-01	9. Qty. 1	10. Serial/Batch No. 76401-04	11. Status/Work New
12. Remarks Right Hand, Modified with Lid Step and Front End Cutout IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature 14c. Approved Organization Number	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 10 June 2011		14d. Name 14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

AERO MASTERS

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice 2010-04	
6. Item	7. Description Cargo Basket	8. Part Number 76410-01-01	9. Qty. 1	10. Serial/Batch No. 76401-01	11. Status/Work New	
12. Remarks Right Hand, Modified with Lid Step and Front End Cutout IAW DCL704						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 11 May 2011		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

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